

y, 09/01/2009 1:35:50 PM  
Lacelle

Process Sheet

CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
44540		
Estimate Number : 13292	Part Number	: D37853
P.O. Number :	Drawing Number	: D3785 REVB PRELIM
This Issue : 09/01/2009 S.O. No. :	Project Number	: N/A
Prsht Rev. : NC	Drawing Revision	: PRELIM
First Issue : / / Type : SMALL /MED FAB	Material	:
Previous Run : 41256	Due Date	: 16/01/2009
Written By : <u>W</u>	Qty:	10 Um: Each
Checked & Approved By : <u>W</u>		
Comment : Est Rev:A 08-05-01 new issue DD verified by:EC		
Est Rev:B 09-01-09 rev.B as per dwg DD verified by:ec		

POSITIVE  
RECALL

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.2758 sf(s)/Unit Total : 2.7584 sf(s)  
6061-T6 .080" Sheet  
batch: 110063 HB 9-1-12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg D3785  
Dwg Rev: PRE HB 9-1-12  
Prog Rev: LIM  
\*\*\*\*grain direction along 3.44"\*\*\*\*  
2- Deburr if necessary HB 9-1-12

③

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
Bend as per Dwg D3785

HB 09/01/14 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 09/01/2009 1:35:50 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 44540

Part Number: D37853

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING  
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

FORWARD 09-01-14 10

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-counter sink holes as per dwg D3785

FF 09/01/14

8.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING  
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

09-01-20 13

09-01-14 10

9.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

090114

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 09/01/14

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

3:45

OVEN TEMPERATURE:

320°

FINISH TIME:

4:15

FF 09/01/14

13

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-20 13

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 120

UF 09-02-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: BRACKET

Job Number: 44540

Part Number: D37853

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09.01.20

POSITIVE RECALL

EFFECTIVE 09.01.20 AUTH h

RELEASED h DATE 09.02.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

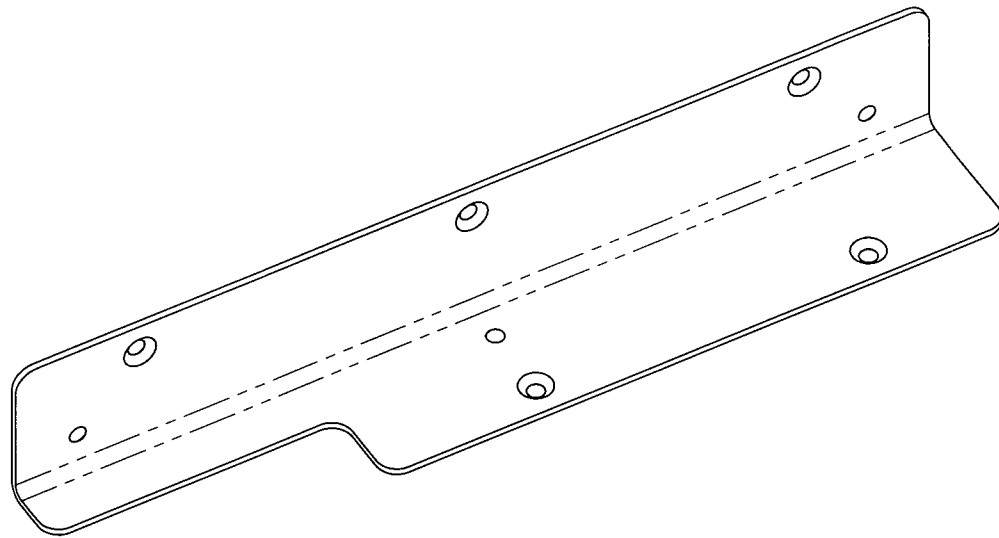
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D3785-3 BRACKET**

**NOTES:**

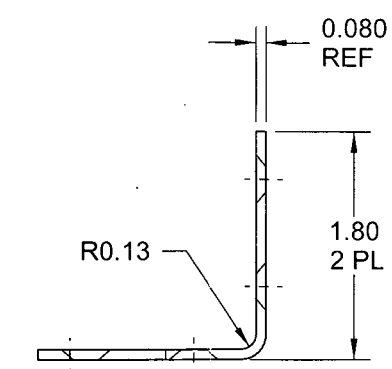
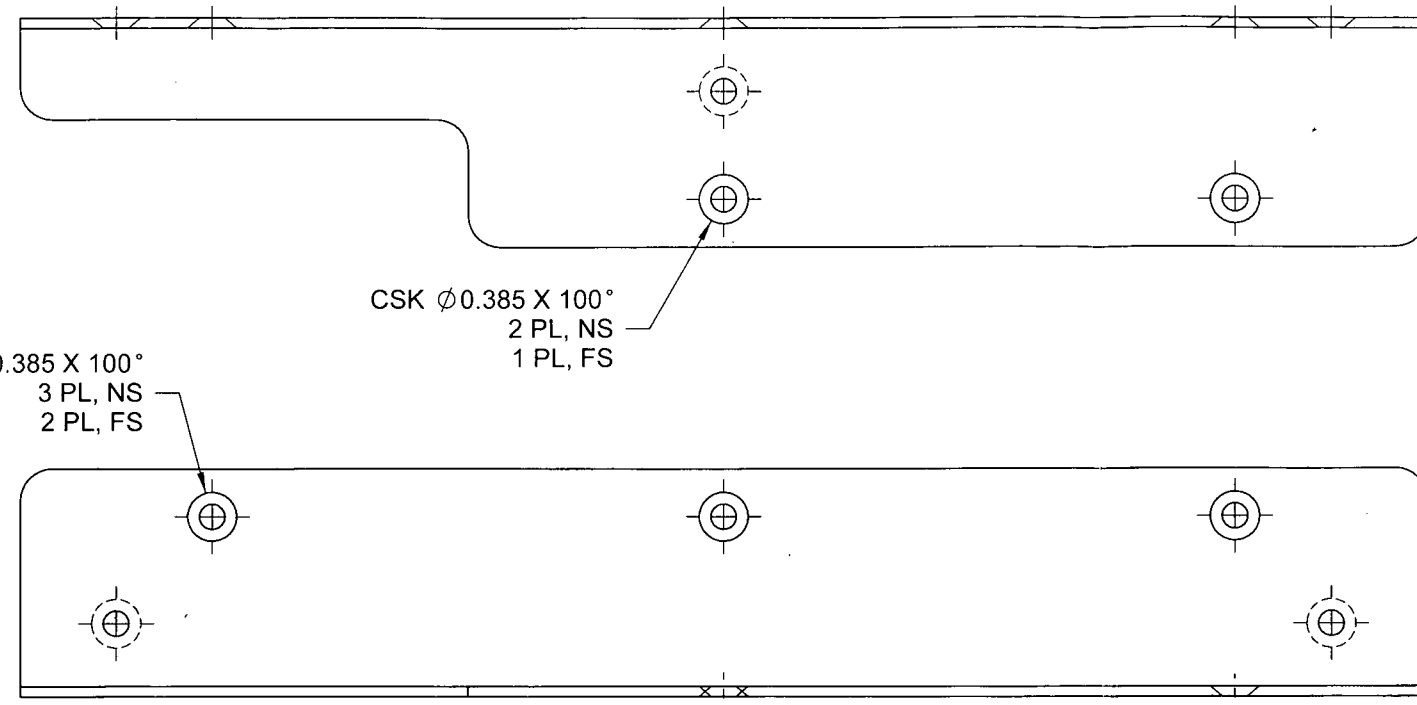
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

**PRELIMINARY ISSUE**

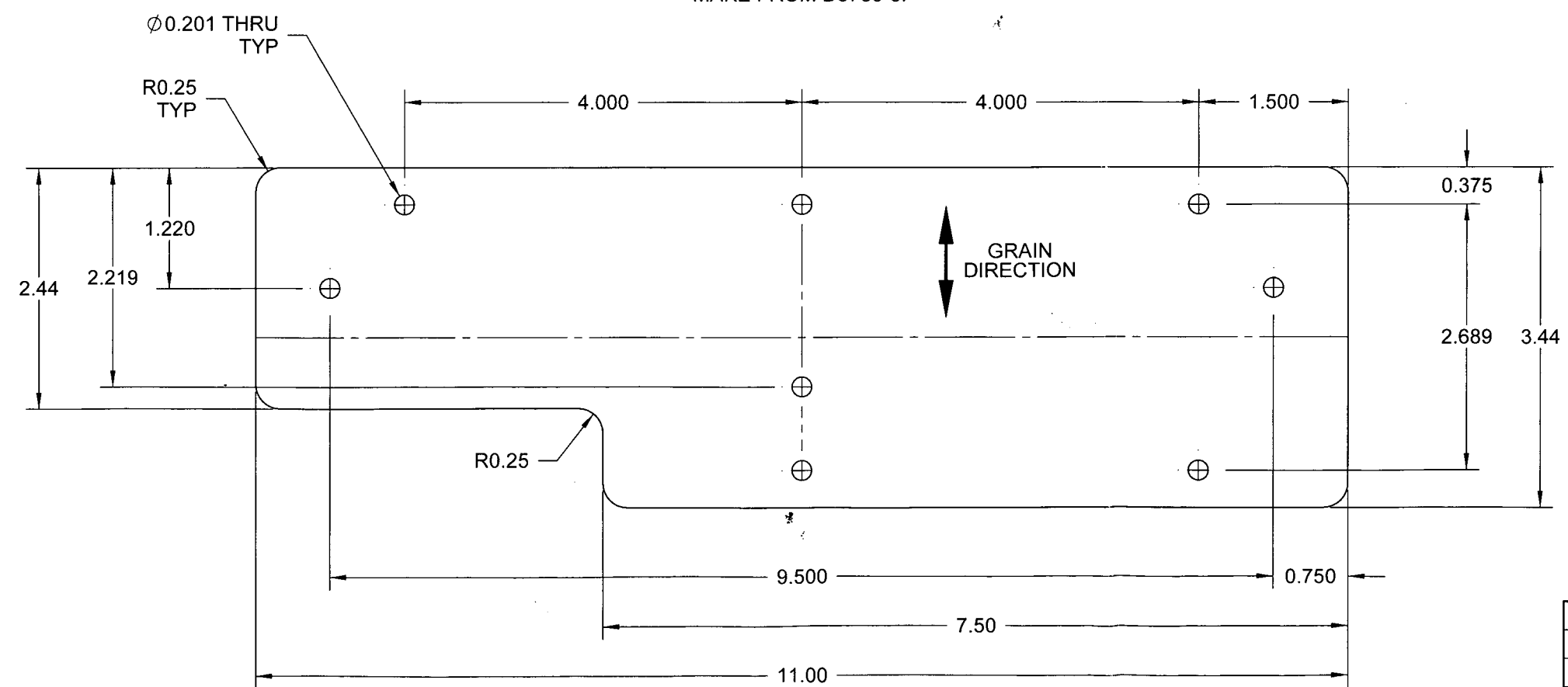
44540  
08.01.04 PM  
08.07.18

B	REDESIGNED D3785-3; REMOVED P/Ns D3785-041/-1/-5/-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3785</b>	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
DATE	08.07.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





**D3785-3 BRACKET**  
MAKE FROM D3785-3F

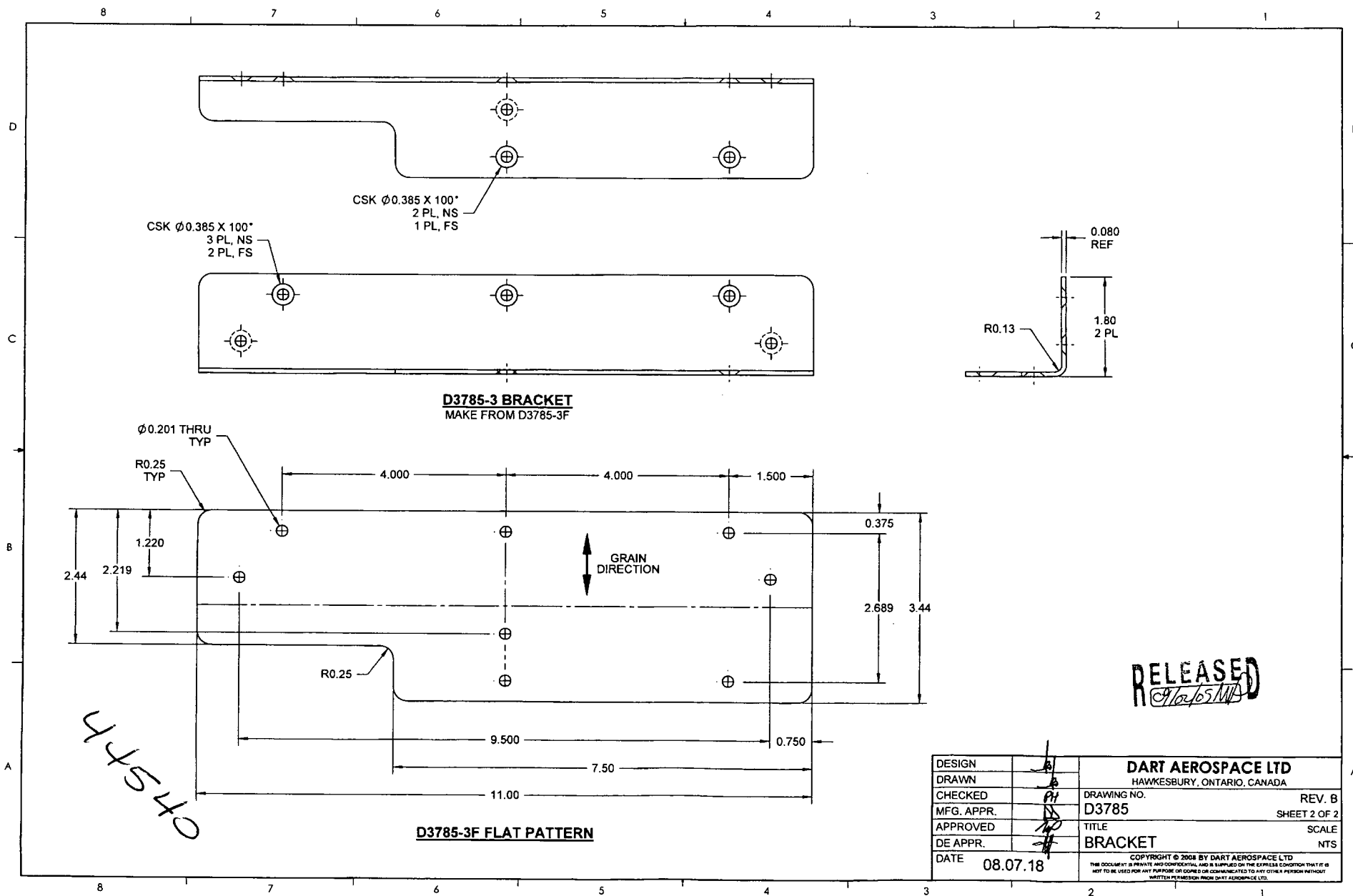


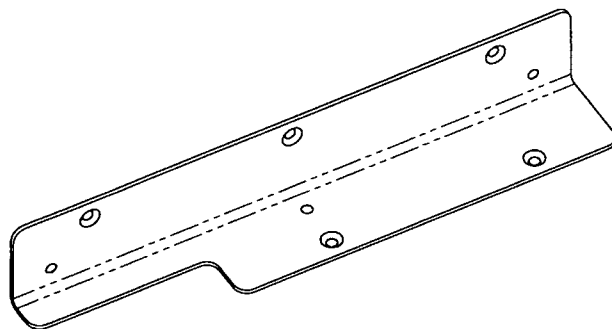
**D3785-3F FLAT PATTERN**

PRELIMINARY ISSUE

0901.09 102  
ECN #09-502

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3785</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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**D3785-3 BRACKET**

RELEASED  
09/04/05

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A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
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APPROVED			
DE APPR.			
DATE	08.07.18		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3785</b>	REV. B SHEET 1 OF 2
TITLE <b>BRACKET</b>	SCALE NTS
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